

24/02

Work Order ID 66531

Friday, February 18, 2011 2:50:53 PM



Item ID: D4148-041

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug Assembly, Fwd

Stop



Start Date: 2/18/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4148

C

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

120

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

[Handwritten signature] 2/11/02/22 (2)

[Handwritten signature]

[Handwritten signature] 2/11/02/22

Work Order ID 66531

Page 2

Friday, February 18, 2011 2:50:53 PM

Item ID: D4148-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Assembly, Fwd

Start Date: 2/18/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/22

ME
11-02-22

Picklist Print

Friday, February 18, 2011 2:50:49 PM

Page 1

Work Order ID: 66531

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 2/18/2011

Required Date: 2/22/2011

Start Qty: 2.00

Required Qty: 2.00





Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC

IPP Rev:B 10.07.22 as per revB DD verf:JLM

10.10.29 as per revC DD verf:EC

IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-6  Lanyard Assembly		Manufactured	No			100	Each	8.0000	1	2			
<div> <div>Location</div> <div>ST020</div> <div>66029</div> </div> <div> <div>Loc Qty</div> <div>8</div> <div>8</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3910-1  Crosstube Lug		Manufactured	No			100	Each	15.0000	1	2			
<div> <div>Location</div> <div>st507</div> <div>59708</div> <div>65631</div> </div> <div> <div>Loc Qty</div> <div>15</div> <div>1</div> <div>14</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D4091-1  Mounting Lug		Manufactured	No			100	Each	0.0000	1	2			
D4148-1  Crosstube Lug Plate, Fwd		Manufactured	No			100	Each	11.0000	2	4			
<div> <div>Location</div> <div>ST132</div> <div>63448</div> <div>65962</div> </div> <div> <div>Loc Qty</div> <div>11</div> <div>1</div> <div>10</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													

B65626 (K)

Handwritten signatures and dates:
 2/22/22
 2/22/22
 2/22/22
 2/22/22
 4

Picklist Print

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Page 2

Work Order ID: 66531

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 2/18/2011

Required Date: 2/22/2011

Start Qty: 2.00

Required Qty: 2.00

D4148-3 Manufactured No

100 Each

4.0000

1



Stud Receiver, Lower

Location

Loc Qty

Loc Code

ST132

4

63722

4

D4148-5 Manufactured No

100 Each

7.0000

1



Eyebolt Stud

Location

Loc Qty

Loc Code

GA

7

66225

7

AN3C12A Purchased No

100 Each

102.0000

4



Bolts

Location

Loc Qty

Loc Code

ST351

102

112314

8

114761

11

116022

2

116289

17

116786

14

116924

50

2
2/11/02/22

2
2/11/02/22

8
2/11/02/22

4

Friday, February 18, 2011 2:50:50 PM

Shop Packet Print

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Work Order ID: 66531

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 2/18/2011

Required Date: 2/22/2011

Start Qty: 2.00

Required Qty: 2.00

AN4C13A

Purchased

No

100

Each

67.0000

1



BOLT

Location

Loc Qty

Loc Code

ST357

67

113359

3

114442

5

114615

2

116191

7

116914

50



2
EPB 11/02/22

MS17984-C413

Purchased

No

100

Each

23.0000

1



PIN, QUICK RELEASE

Location

Loc Qty

Loc Code

ST315

23

116706

3

116823

20



2
EPB 11/02/22

MS20615-4M18

Purchased

No

100

Each

209.0000

8



Rivet

Location

Loc Qty

Loc Code

ST323

209

114808

128

115037

81



16
EPB 11/02/22

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Shop Packet Print

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Page 4

Work Order ID: 66531

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 2/18/2011

Required Date: 2/22/2011

Start Qty: 2.00

Required Qty: 2.00

MS21043-3

Purchased

No

100

Each

1,276.000

4

8



Nut



EP 11/02/22

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

1200

112314

1200

84

MS21043-4

Purchased

No

100

Each

963.0000

1

2



Nut



EP 11/02/22

Location

Loc Qty

Loc Code

ST301

963

114523

5

114784

2

115936

60

116188

596

116549

300

26

NAS1149C0332R

Purchased

No

100

Each

2,816.000

8

16



Washer



EP 11/02/22

Location

Loc Qty

Loc Code

ST297

2816

115000

125

115698

35

116025

108

116304

2548

8

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Shop Packet Print

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Picklist Print

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Work Order ID: 66531



Parent Item: D4148-041



Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 2/18/2011

Required Date: 2/22/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1149C0432R

Purchased

No

100

Each

2,146.000

2

4



Washer



EP 11/02/22

Location

Loc Qty

Loc Code

ST297

2146

114292

36

116304

91

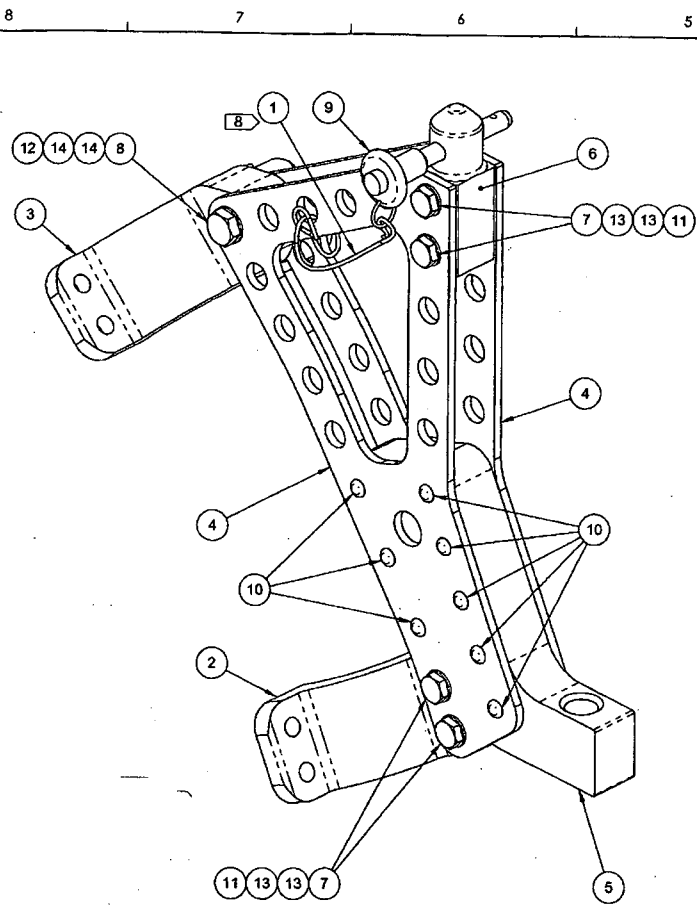
116805

93

116900

1926

#12



D4148-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" PER DART QSI 044 6.1
- 7) WEIGHT: 3.63 lbs
- 8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4148-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	1	D3910-1	X-TUBE LUG
3	1	D4091-1	MOUNTING LUG
4	2	D4148-1	FWD X-TUBE LUG PLATE
5	1	D4148-3	STUD RECEIVER LOWER
6	1	D4148-5	EYEBOLT STUD
7	4	AN3C12A	BOLT
8	1	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	8	MS20615-4M18	RIVET
11	4	MS21043-3	NUT
12	1	MS21043-4	NUT
13	8	NAS1149C0332R	WASHER
14	2	NAS1149C0432R	WASHER

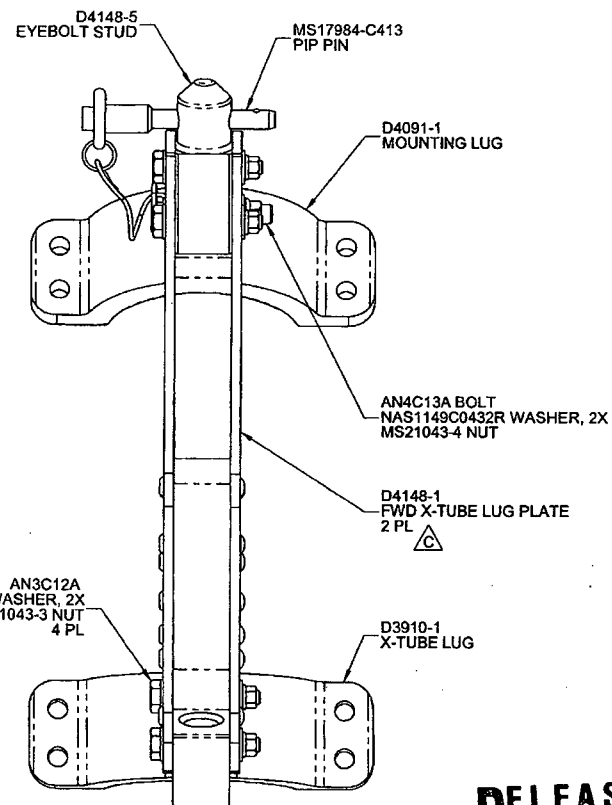
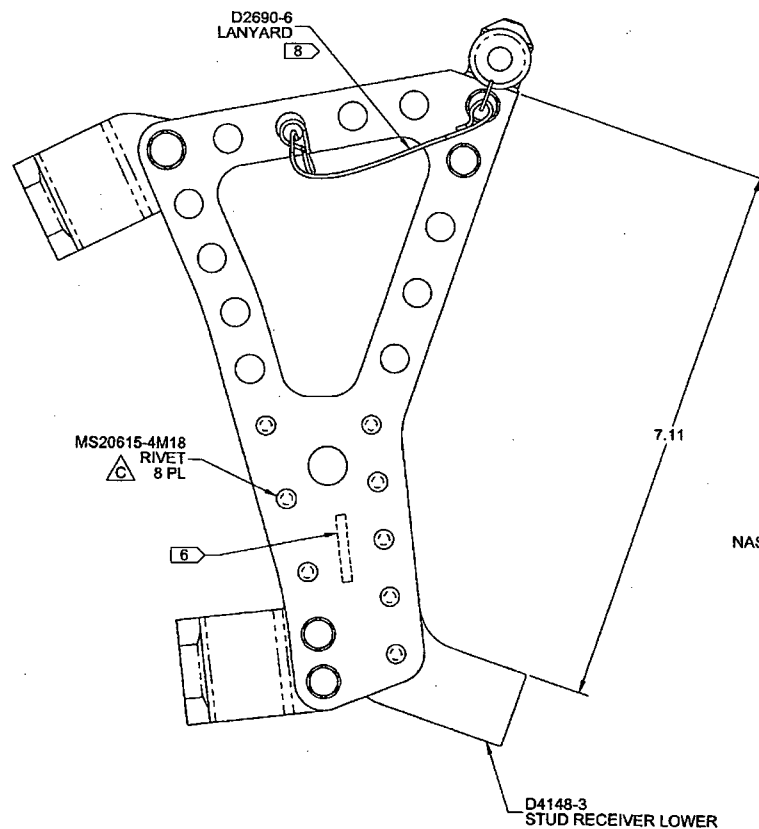
RELEASED
2010-10-28

C	REDESIGNED D4148-1/3 TO ADDRESS COMPATIBILITY ISSUES WITH D350-591 SHORT STEPS	MB	10.10.12
B	REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN D6-3); Ø0.129 7 PL WAS 10 PL (ZN A7-3); Ø0.191 WAS 0.129 (ZN C8-5) REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.10.12		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4148** REV. C
SHEET 1 OF 5
TITLE **FWD X-TUBE LUG ASSY** SCALE NTS

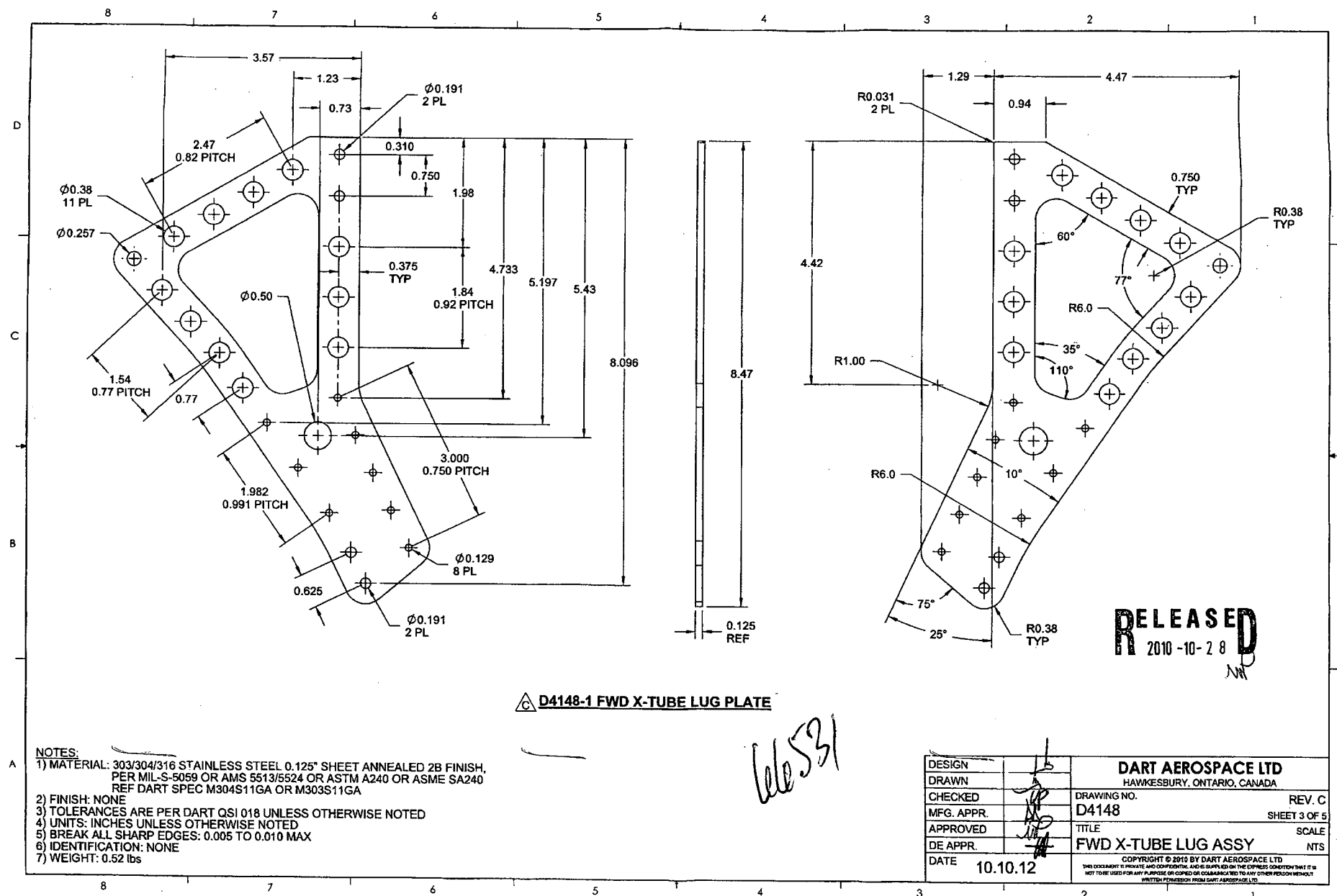
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D4148-041 FWD X-TUBE LUG ASSY

DESIGN		DART AEROSPAC LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4148	REV. C
MFG. APPR.		TITLE FWD X-TUBE LUG ASSY	SHEET 2 OF 5
APPROVED		SCALE	NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPAC LTD	
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D4148-1 FWD X-TUBE LUG PLATE

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.52 lbs

W6531

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO. D4148	REV. C
MFG. APPR.		TITLE	SHEET 3 OF 5
APPROVED		FWD X-TUBE LUG ASSY	SCALE
DE APPR.			NTS
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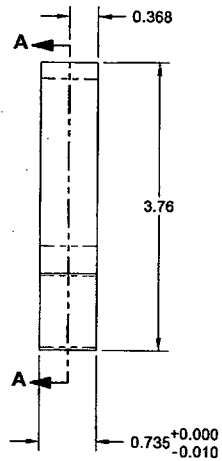
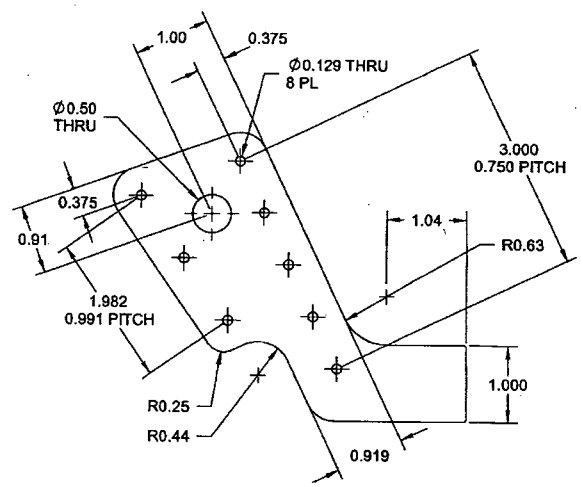
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D

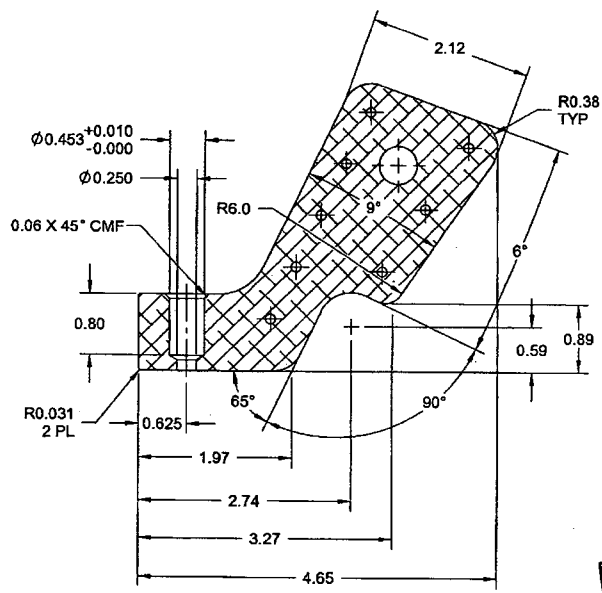
C

B

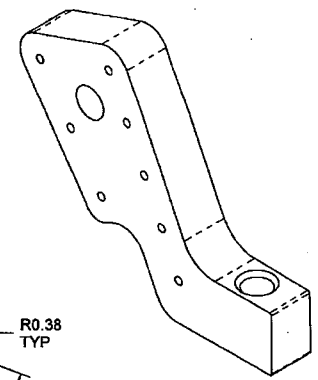
A



D4148-3 STUD RECEIVER LOWER



SECTION A-A



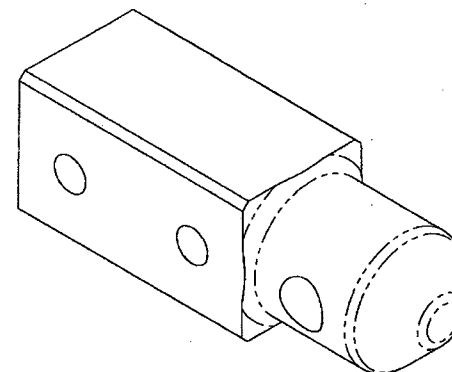
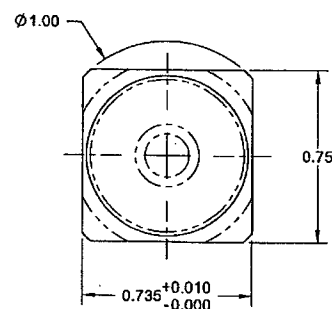
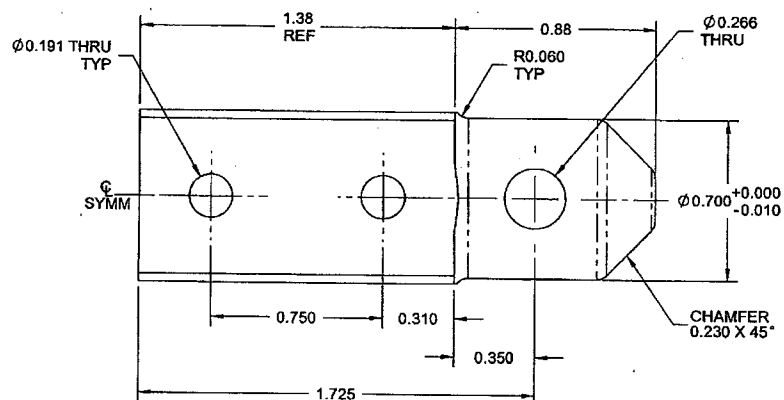
RELEASED
2010-10-28

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR AS 1M A276 REF DART SPEC M304B OR M303B
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.52 lbs

60531

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4148	REV. C
MFG. APPR.			SHEET 4 OF 5
APPROVED		TITLE FWD X-TUBE LUG ASSY	SCALE
DE APPR.			NTS
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8 7 6 5 4 3 2 1



D4148-5 EYEBOLT STUD

RELEASED
2010-10-28

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs

66531

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4148	REV. C
MFG. APPR.		TITLE	SHEET 5 OF 5
APPROVED		FWD X-TUBE LUG ASSY	SCALE
DE APPR.			NTS
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